

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. J AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-636 REV. 3

REF FAA STC: SR00646SE
REF TCCA STC: SH99-7
REF EASA STC: EASA.10033942
REF BRAZIL STC: 2009S05-01

1.0 Purpose

It has come to DART's attention that the fit between the 12 mm Bolt required to fasten the aft most float mounting bracket of the Aerazur Floatation System to the existing provisions in the DART Skid tubes may be too loose. In such cases, it is acceptable for the installer or maintainer to proceed with the following steps:

2.0 Blade Fitting Rework

- 2.1 Locate $\varnothing 0.508$ in (12.9mm) hole in the D3488-041/-042 Blade Fittings and enlarge to $\varnothing 0.610$ in (15.5mm), then ream to $\varnothing 0.626$ in $+0.001$ in/ -0.000 in (15.5mm $+0.15/-0$) as shown in Figure 1 of this Service Instruction.
- 2.2 Deburr and touch up finish in accordance with Chapter 5 of ICA-D350-636.

3.0 Bushing Fabrication

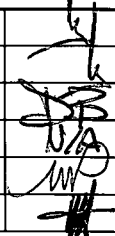
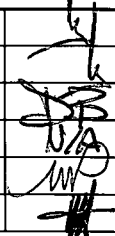
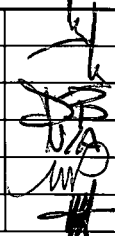
- 3.1 Fabricate qty(1) bushing for each Blade Fitting Assembly in accordance with Figure 2 of this Service Instruction and to the following material specifications: 7075-T73 (or 7075-T7351/T73510/T73511) round bar per AMS-QQ-A-200/11 or AMS-QQ-A-225/9.
- 3.2 Ensure the bushings can be installed into the holes that have been reworked on the D3488-041/-042 Blade Fitting Assemblies: the edges of the bushing should not protrude from the surface of the D3488-041/-042 Blade Fitting Assemblies. Adjust length of bushings to clear as required.

4.0 Installation

- 4.1 Bond bushings to the D3488-041/-042 Blade Fitting Assemblies using Proseal 890 Class B or AMS-S-8802 Class B sealant or 3M DP460 Scotch-Weld Epoxy Adhesive in accordance with the manufacturer's instructions. Ensure the inside of the bushings are free from sealant or adhesive. Refer to Figure 3 of this Service Instruction.
- 4.2 Allow sealant or adhesive to cure in accordance with the manufacturer's instructions.
- 4.3 Install the reworked D3488-041/-042 Blade Fitting Assemblies in accordance with Chapter 3.5 of IIN-D350-636 or Chapter 32.4 of ICA-D350-636.

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

A	NEW ISSUE	MB	14.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9711	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BLADE FITTING REWORK	NTS
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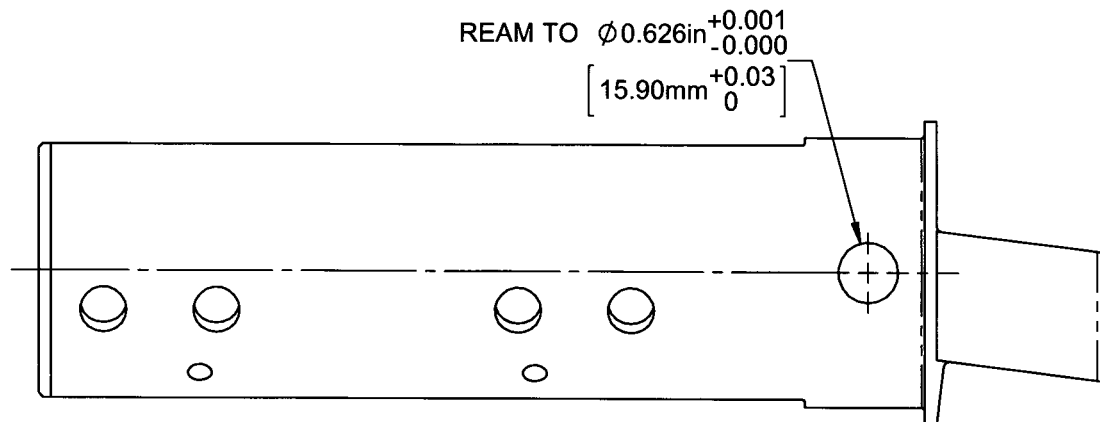


FIGURE 1: Blade Fitting Assembly Rework

(D3488-042 Shown, D3488-041 Similar)

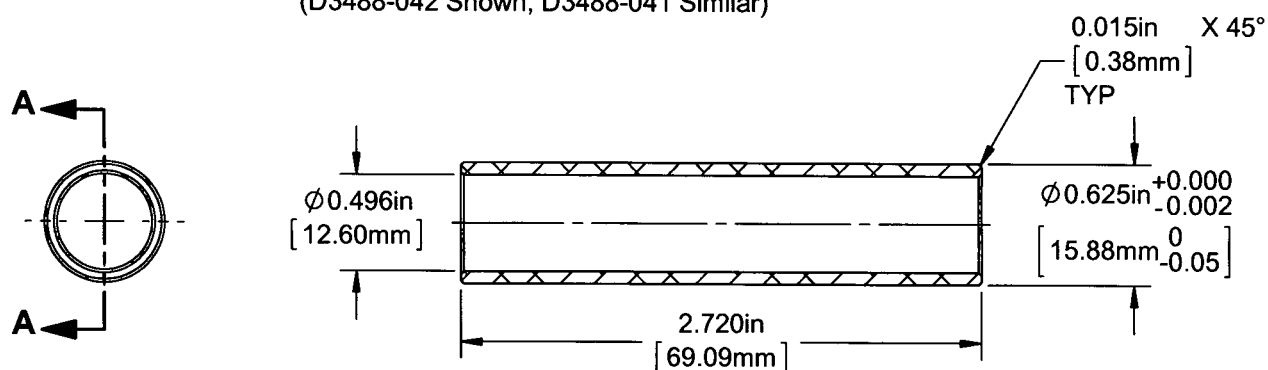


FIGURE 2: Bushing Detail

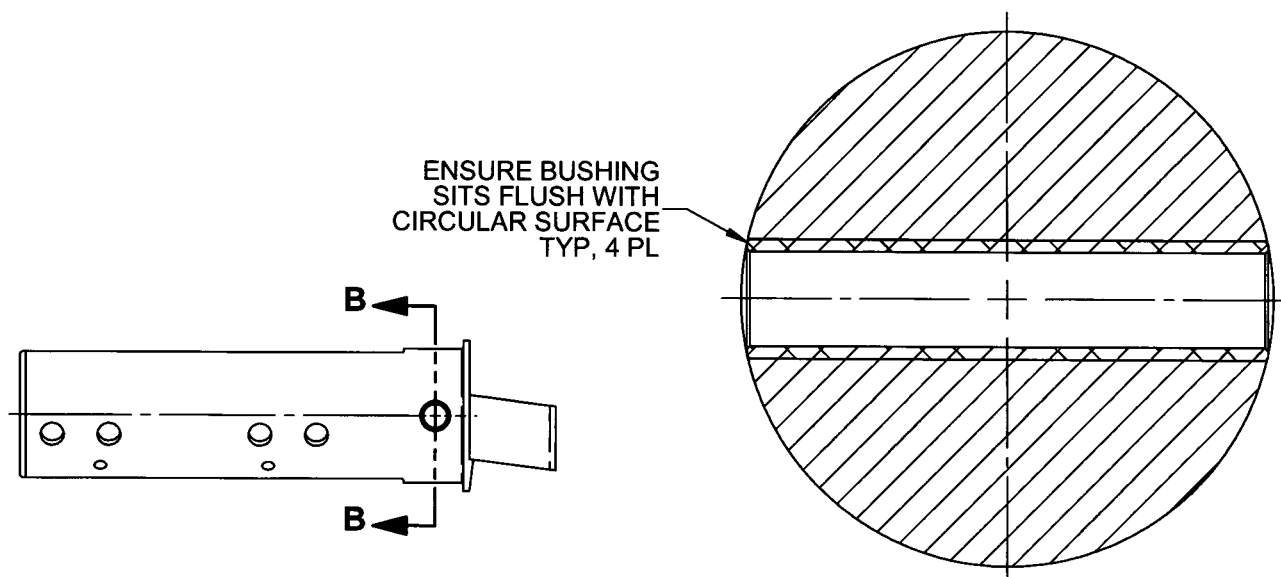


FIGURE 3: Assembly Detail

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DRAWN	<i>HL</i>	KENT, WA	
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MFG. APPR.	<i>N/A</i>	DSI 9711	SHEET 2 OF 2
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